

Date: Thursday, 13/11/2008 9:08:38 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001` Dart Helicopters Services			Drawing Name	: SIDE (RH)		
Job Number	: 43112			Part Number	: D32542		
Estimate Number	: 10890			Drawing Number	: D3254 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/11/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : PURCHASED PARTS			Due Date	: 20/11/2008 Qty: 2 Um: Each		
Previous Run	: 43112						
Written By	:						
Checked & Approved By	: <u>JUL 08. 11.13</u>						
Comment	: Est. B 04.10.26 D3254-2 no longer made in-house est c 08.11.13 in-house EC verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
	Comment: Qty.: 3.5385 sf(s)/Unit Total : 7.0770 sf(s) 2024-T3 .063 sheet	
	Batch: <u>109 463</u> <u>HB 8-11-13</u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3254	
	Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>HB 8-11-13</u>	<u>(2)</u>
	2-Deburr if necessary	<u>HB 8-11-13</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>HB 8-11-13</u>
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<u>S 08/11/13 (2)</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Bend as per dwg D3254	<u>HB 07/11/13</u>
		<u>(2)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 9:08:38 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE (RH)

Job Number: 43112

Part Number: D32542

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sa8ulie ④

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

28 08-11-18 X2

8.0 POWDER COATING

POWDER COATING



M105642

2X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

3:30
01

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M/L 08/11/19

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/11/20

②

10.0 PACKAGING 1

PACKAGING RESOURCE #1



2X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1-16

8/11/20

SP

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/24 08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43112
Description: Side (Dual Battery Rack)	Part Number:	D3254-2
Inspection Dwg: D3254	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: 1P

Audited by:

Prototype Approval: N/A

Date: 8-11-13

Date: 8/11/14

Date: N/A

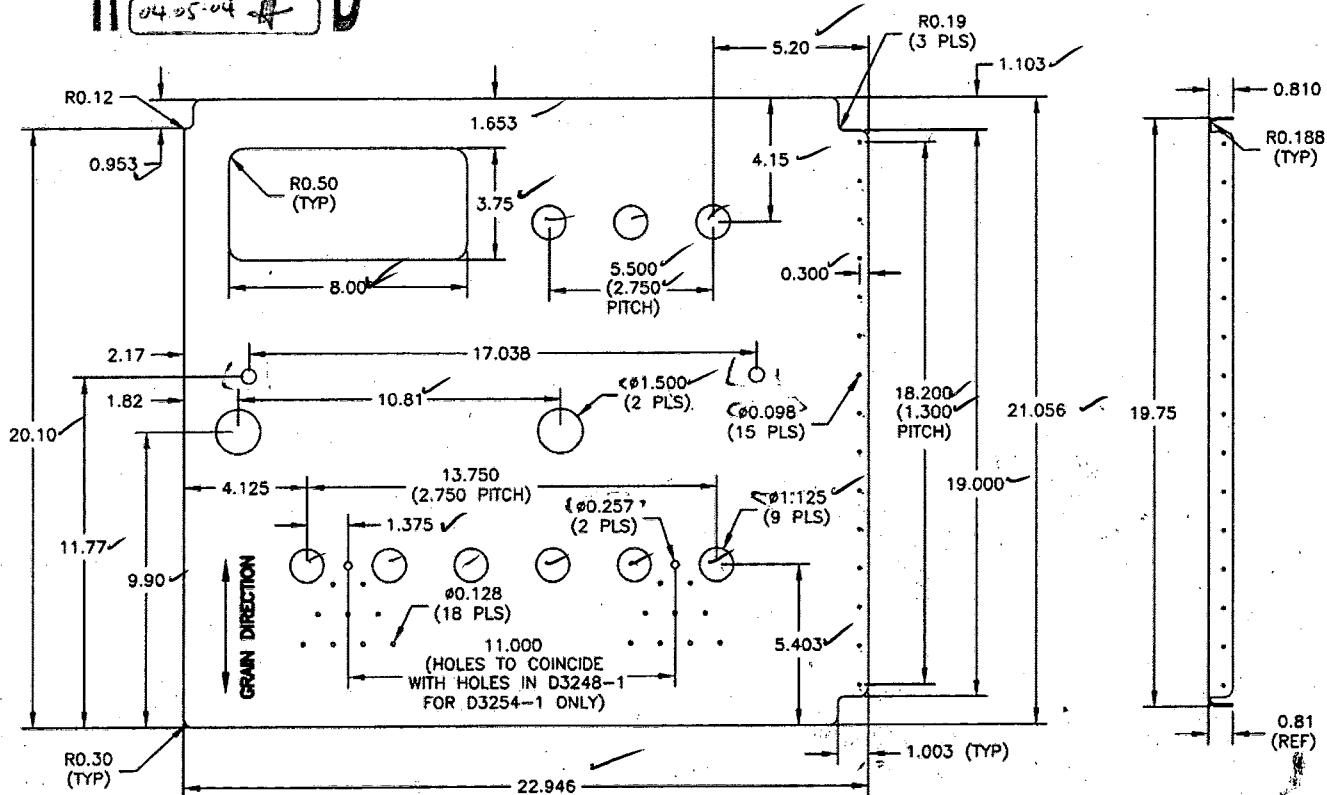
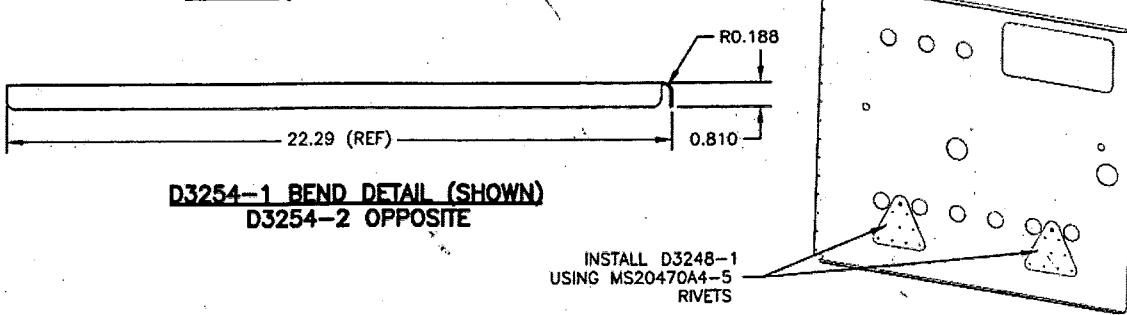
Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	P/O D205-579-015	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	P/O D205-579-015	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

H:\FORMS\Quality Assurance\approved QA\FAI revD

DARTCOPY 65
030

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A D3254
DATE		SHEET 1 OF 1
04.04.06		TITLE SIDE (DUAL BATTERY RACK)
		SCALE 1:6
A	04.04.06	NEW ISSUE

RELEASED
04.05.04**D3254-1/-2 FLAT PATTERN**

D3254-041 SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. 431

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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